

Date: Tuesday, 22/04/2008 3:53:13 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, OUTBOARD, RH, 206		
Job Number	: 38750		Part Number	: D26652		
Estimate Number	: 10523		Drawing Number	: D2665 REV. D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 22/04/2008		Drawing Revision	: D		
Prsh Rev:	: NC		Material	:		
First Issue	: / /		Due Date	: 10/05/2008		
Previous Run	: 37331		Qty:	12 Um: Each		
Written By	:					
Checked & Approved By	: JLD 08.4.23					
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC					
	Est Rev:D As per Rev D 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	Saddle Billet, 7075
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-2 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 28/06/20
D206-642 QA: N/C Closed: D Date: 28/06/20

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 38750

Part Number: D26652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



30 min

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 00/0

16/06/2008

S.022 13.46

#1 318.1 F

#2 1338750 F

#3 D26652 F

#4

7.0 POWDER COATING

POWDER COATING



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 08/18/08

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



08-06-16

(XII)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 436

AS 08/06/17 F11

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/18 FJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-06-17

Dart Aerospace Ltd
W/O: _____
DATE: _____

WORK ORDER CHANGES

STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38750
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.114	.116	.117	.120		
B	0.100	0.140		.127	.125	.125	.0.123		
C	1.125	1.145		1.134	1.134	1.135	1.133		
D	0.615	0.685		.685	.680	.680	.680		
E	0.240	0.260		.253	.253	.253	.252		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		.222	.218	.218	.223		
H	0.100	0.180		.132	.130	.130	.0.135		
I	2.470	2.510		2.491	2.499	2.500	2.492		
J	1.565	1.585		1.575	1.575	1.597	1.597		
K	0.235	0.240		.239	.23	0.239	0.239		
L	0.100	0.120		.108	0.	0.110	0.110		
M	0.990	1.010		1.004	0.994	0.994	0.995		
N	0.510	0.515		.510		0.512	0.512		
O	5.990	6.010		5.997	6.001	6.001	6.000		
P	1.245	1.255		1.250	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.316	0.3155	0.3155	0.3155		
S	0.315	0.322		.319	.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.367	1.367	1.367		
V	0.787	0.807		.799	.796	.791	0.797		
W	0.540	0.560		.540	.548	.556	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	.259	.257	.259		
Z	0.912	0.932		.917	.917	.917	0.915		
AA	0.490	0.510		.501	0.506	0.506	0.506		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									

Accept/Reject

Reject Reject Reject

Measured by:	<i>J.S.</i>
Date:	08/06/01

Audited by:	<i>J.S.</i>
Date:	08/06/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>J.S.</i>

DART AEROSPACE LTD	Work Order:	38750
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.125	0.1195	0.1145	0.115		
B	0.100	0.140		0.131	0.129	0.123	0.120		
C	1.125	1.145		1.1325	1.132	1.127	1.127		
D	0.615	0.685		.680	0.685	0.680	0.680		
E	0.240	0.260		.260	0.253	0.256	0.257		
F	1.313	1.343		1.325	1.326	1.322	1.321		
G	0.210	0.230		.225	0.224	0.2205	0.220		
H	0.100	0.180		0.136	0.136	0.140	0.140		
I	2.470	2.510		2.491	2.493	2.500	2.500		
J	1.565	1.585		1.573	1.572	1.566	1.567		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.995	0.992	0.995		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.000	6.000	5.997	6.000		
P	1.245	1.255		1.250	1.249	1.2485	1.250		
Q	2.495	2.505		2.500	2.500	2.4995	2.500		
R	0.313	0.318		0.3155	0.3155	0.315	0.3155		
S	0.315	0.322		.320	0.322	0.316	0.315		
T	2.495	2.505		2.500	2.498	2.497	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.798	0.793	0.796		
W	0.540	0.560		0.549	0.550	0.550	0.5505		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.259	0.260	0.261	0.260		
Z	0.912	0.932		0.920	0.920	0.920	0.918		
AA	0.490	0.510		0.5005	0.502	0.498	0.502		
AB	0.178	0.198		.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	84P	/	DTP	Audited by:	
Date:	08/06/10	/	08/06/10	Date:	08/06/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	SPH

DART AEROSPACE LTD	Work Order:	38750
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

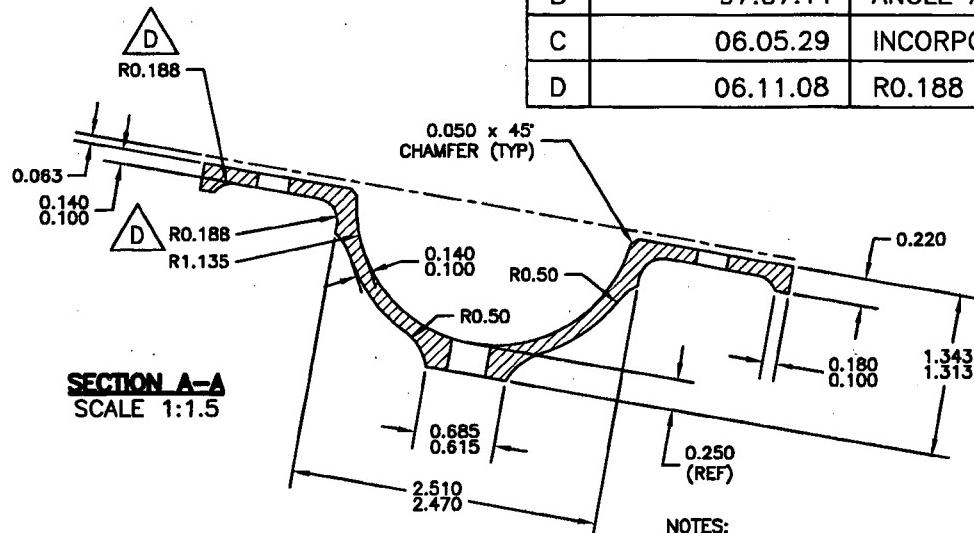
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11 1/2	12		
A	0.100	0.140		0.114	0.113	0.114	0.113		
B	0.100	0.140		0.120	0.120	0.120	0.120		
C	1.125	1.145		1.1315	1.1305	1.131	1.131		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.253	0.252	0.252	0.252		
F	1.313	1.343		1.3235	1.324	1.324	1.323		
G	0.210	0.230		0.220	0.219	0.220	0.220		
H	0.100	0.180		0.140	0.140	0.138	0.138		
I	2.470	2.510		2.500	2.500	2.499	2.500		
J	1.565	1.585		1.571	1.571	1.571	1.570		
K	0.235	0.240		.239	.239	.239	.239		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.995	0.995	0.995		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.001	6.000	6.000		
P	1.245	1.255		1.249	1.250	1.249	1.248		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.3155	0.3155	0.3155	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.795	0.797	0.796		
W	0.540	0.560		0.551	0.5505	0.551	0.552		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.919	0.918	0.919	0.919		
AA	0.490	0.510		0.501	0.503	0.502	0.503		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>DTP</i>	Audited by:	<i>S</i>
Date:	08/06/11	Date:	08/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<i>JLM</i>
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>JLM</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665 REV. D
DATE		SHEET 1 OF 1
06.11.08		SCALE 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313



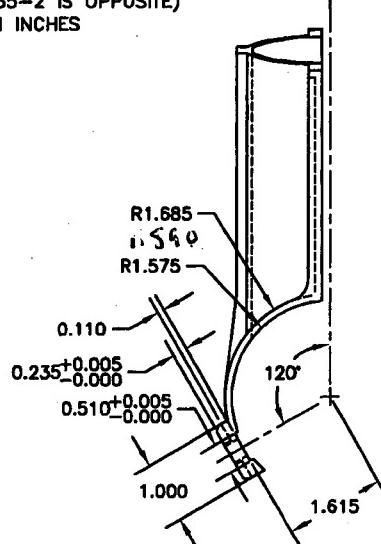
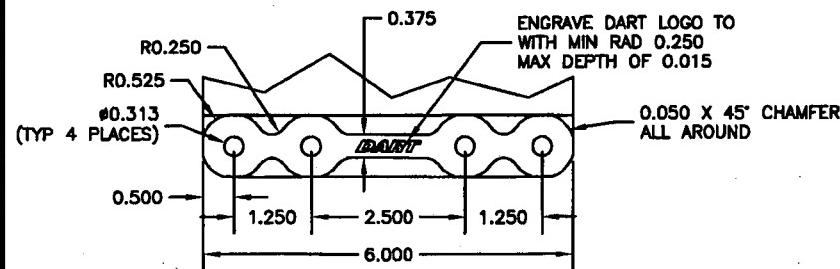
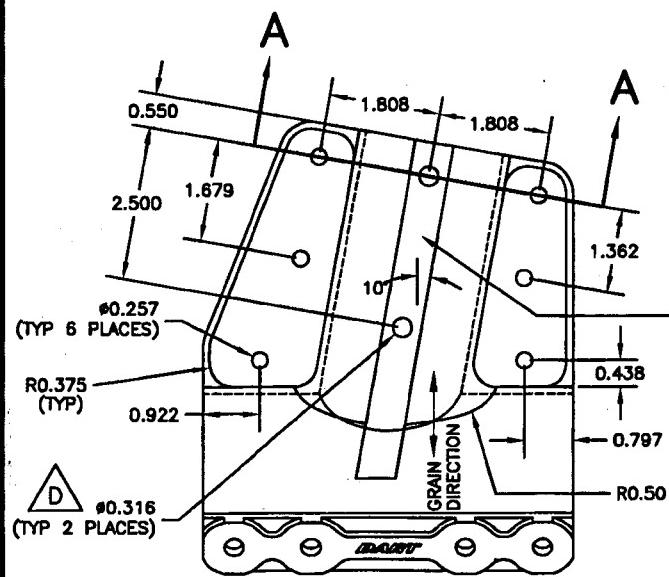
RELEASED

07.02.12

SECTION A-A
SCALE 1:1.5

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 30750

D2665-1 SADDLE FWD OUTSIDE HIGH